

DART AEROSPACE LTD		Work Order:	23877
Description: <i>Wet Plate Ass.</i>		Part Number:	D2873-043
Dwg: D2873 Rev A		Qty:	2
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	MN	Cut Blanks: 1.00" x <sup>0.375"</sup> <del>1.250</del> x 3.700" Long Mat: 6061-T6 (QQ-A-225/B or QQ-A-200/B) Batch: M7321 (m6061T6B1.000x.375) 5208	<i>ml</i>	05/07/26 <del>05-07-25</del>	2 <del>2</del>
3	MN	Machine As per Folio FAS46: Dwg D2873	<i>ml</i>	05/07/26 <del>05-07-25</del>	2 <del>2</del>
4	QC2	Inspect Parts as they come off the CNC Machine.	<i>ml</i>	05/07/26 <del>05-07-25</del>	2 <del>2</del>
5	QUB	Second Check.	<i>ml</i>	05/07/26 <del>05-07-25</del>	2 <del>2</del>
6	QUB	Third Check.	<i>ml</i>	05/07/26 <del>05-07-25</del>	2 <del>2</del>
7	GA	C'SINK as per Dwg D2873.	<i>ml</i>	05/07/26	2
8	QUB	Deburr Work to Step #7.	<i>ml</i>	05-07-25	2
9	FP	Chemical Conversion Coat as per Part QSI 005 4.1.	<i>ml</i>	05/07/26	2
10	QC3	Inspect Chemical Conversion Coat.	<i>ml</i>	05-07-26	2

Rev	Date	Change	Revised By	Approved

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
10	GA	Pick:			
		Qty Part# Desc Batch			
		3 MS21075L5 NutPlate M18119			2
		6 MS20426AD4-96 RIVET M2930			
		Assemble as per Dwg 02873			
12	OS	Inspect work to Step#9.		05/07/20	2
13	ST	Identify in Stock.		05/07/20	2
14	AC	Cost/PART. 78.02 74.02		05/08/02	2
15	DC	Close w/o. Level 21.		05/08/02	2

D. AEROSPACE LTD		Work Order:	23877
Description:		Part Number:	D2873-3
Inspection Dwg:	Rev:	Page 1 of 1	

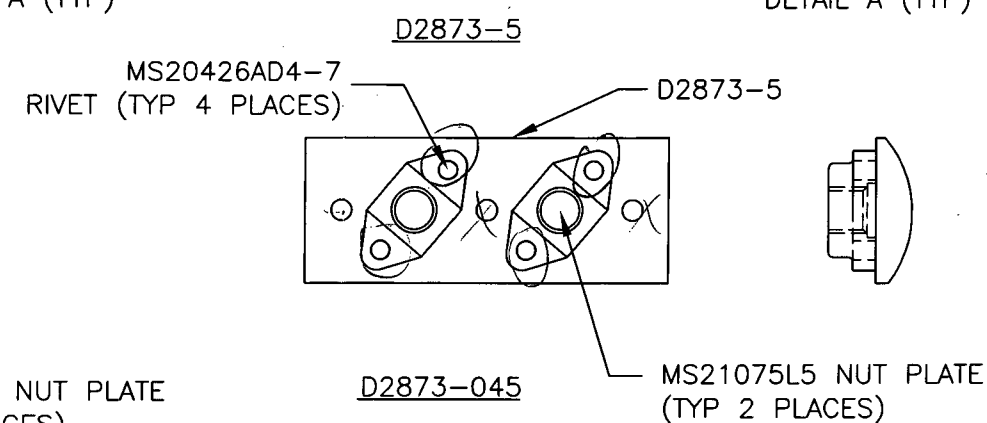
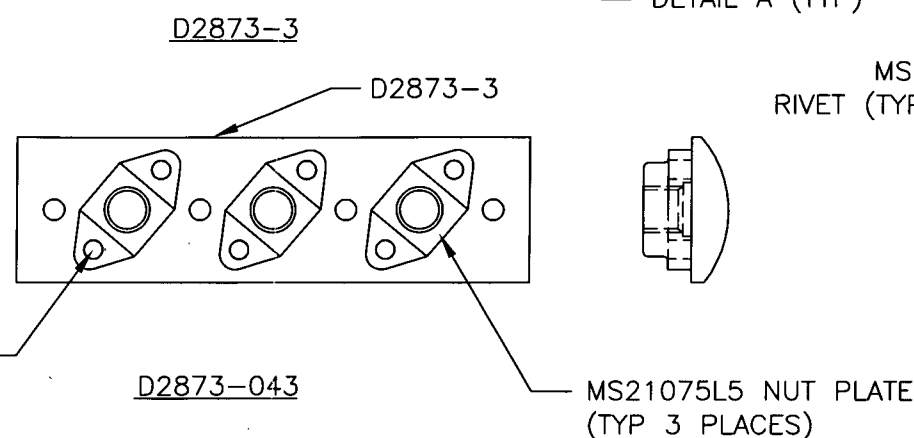
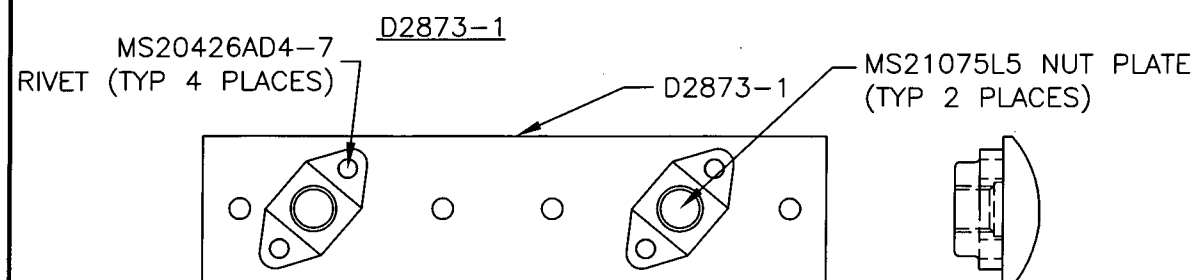
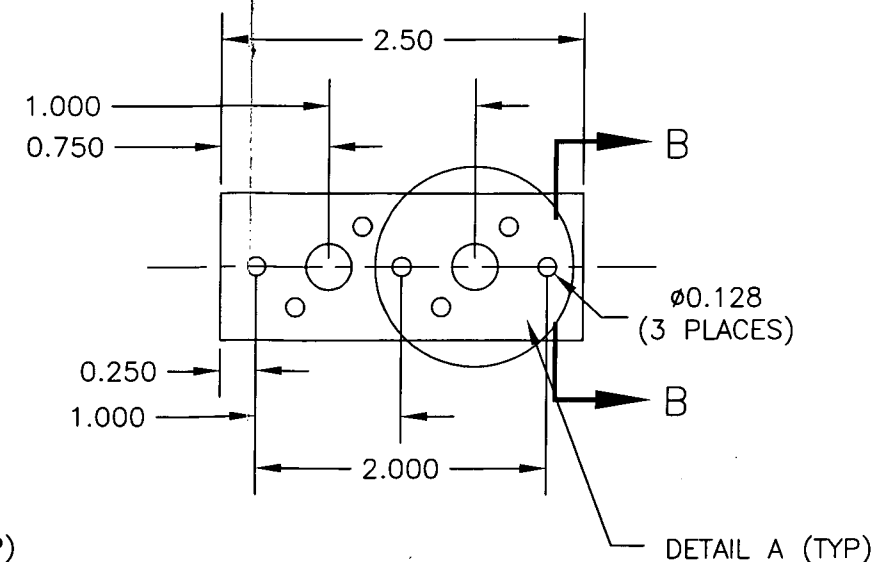
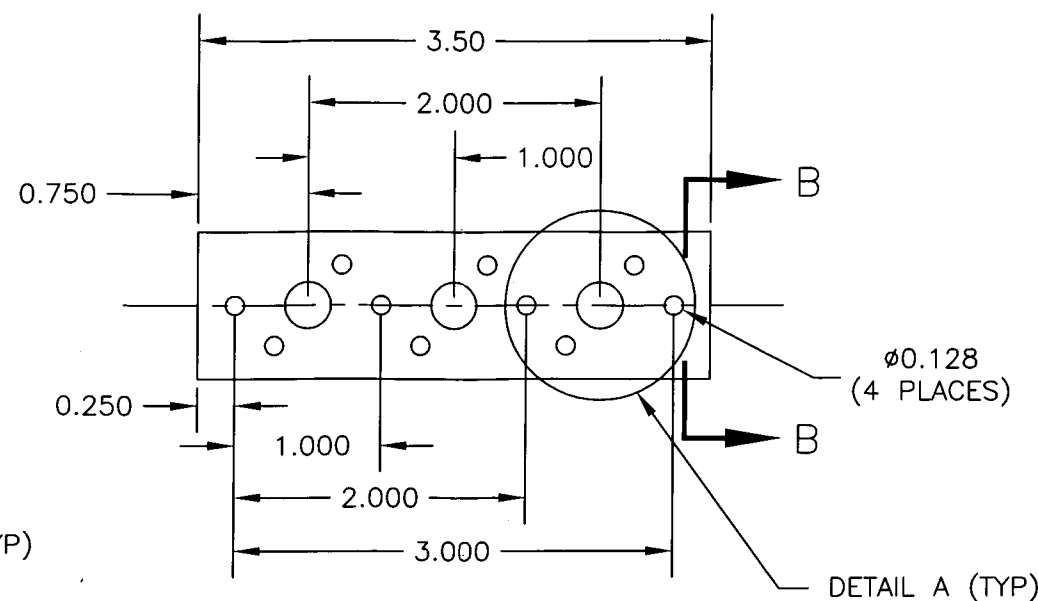
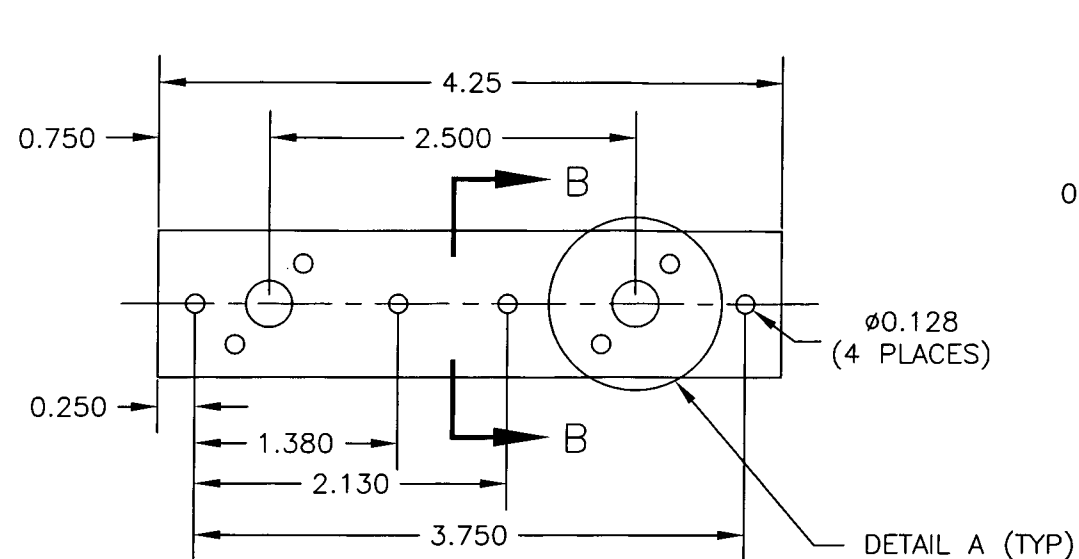
### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	$\pm 0.03$	3.501	✓			
2.000	$\pm 0.01$	2.000	✓			
1.000	"	1.000	✓			
$\phi .128$	$+0.005$ $-0.001$	$\phi .130$	✓			
3.000	$\pm 0.005$	3.000	✓			
2.000	"	2.001	✓			
1.000	"	1.000	✓			
0.250	$\pm 0.000$	0.249	✓			
0.750	"	0.749	✓			
<hr/>						
0.061	$\pm 0.01$	0.060/0.090	Pass	✓		Not equal each side
R.80	"	R.80	✓			
0.250	"	0.257	✓			
1.000	"	0.993	✓			
0.230	$\pm$	0.230	✓			
0.125	$\pm 0.010$	0.124	✓			

Measured by:	<i>PH</i>	Audited by:	<i>PH</i>	Prototype Approval:	<i>PH</i>
Date:	05.07.25	Date:	05.07.25	Date:	05.07.25

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



MS20426AD4-7  
RIVET (TYP 6 PLACES)

MS21075L5 NUT PLATE  
(TYP 3 PLACES)

MS21075L5 NUT PLATE  
(TYP 2 PLACES)

#### D2873-1/-3/-5 RADIUS BLOCK

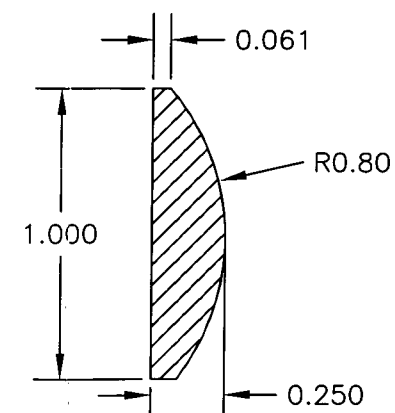
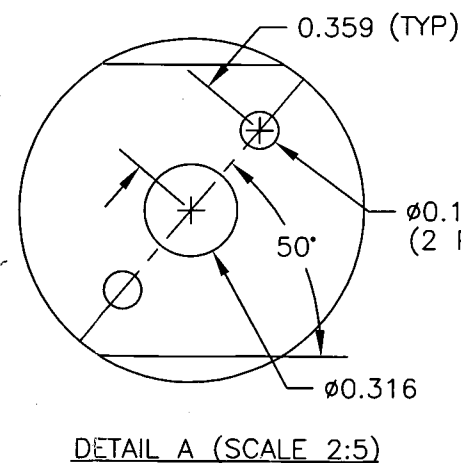
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) C'SINK CURVED SIDE  $\phi 0.225 \times 100^\circ$

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-7 RIVETS

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-7	RIVET
2	3	2	MS21075L5	NUT PLATE



PH 05.07.25

+ C'BORE  
 $\phi 0.230 \times 0.125$  DEEP  
FROM CURVED SIDE +  
FLAT

SECTION B-B (SCALE 2:5)

A	05.05.06	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2873
DATE 05.05.06	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

